

Date: Wednesday, 29/04/2009 3:03:59 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : SIDE DOOR
<b>Job Number</b> : 47621	
<b>Estimate Number</b> : 12296	
<b>P.O. Number</b> :	<b>Part Number</b> : D350589042
<b>This Issue</b> : 29/04/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2991 REV.C
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 45407	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 20/05/2009 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 09.04.09</u>	
<b>Comment</b> : est rev. A 06.02.16 new issue (was done on D350-589-041) EC Est Rev:B 08-02-20 ECN1096 DD verified by: EC est rev C 08.06.26 revised pick list per QC comments (w/o25886) EC verified : DD est rev D 09.02.18 ecn 09-523, chg003 EC verified:DD	



## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



*Handwritten:* JLD  
09/05/11



Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPP D350-589-042

CHG003

CHG004

406.05.11

2.0	OUTSIDE SERVICE	OUTSIDE SERVICES-ENGINEERING
-----	-----------------	------------------------------



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 8723

Description: D2991-2 side door

Supplier: Delastek

Ship to delastek: Qty 2. D2992-1

Doubler

batch:

B46789 x 09/05/06 x 2.

Ensure batch # on Label D3721-2 match W/O # for D350-589-042

Certificate of Conformity and process sheet from Delastek is required

3.0	D29921	Doubler
-----	--------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Doubler

*Handwritten:* N/A INSTALLED at Delastek

4.0	D29912	Side Door
-----	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Side Door

*Handwritten:* 47621 090618

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
09.05.01	1	KITS NOW AT CHG 004 WY 4.00" WIDE DZ99Z-1 DOUBLER				CP 09.05.16 pc QSI 042	[Signature]	
09.05.01	2	SHIP MODIFIED DZ99Z-1 DOUBLERS - 4.00" WIDE x 3.250" TALL x 0.040 THICK SUSL-H32 W/ RO.250 CORNERS				CP 09.05.16 pc QSI 042	[Signature]	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 29/04/2009 3:04:00 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SIDE DOOR

Job Number: 47621

Part Number: D350589042

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Receive & Inspect For Transit Damage  
Ensure certificate of conformity is attached

**ENGINEERING  
APPROVAL**

CP 09.06.19

4/9/15 (U)

6.0 QC6 DIMENSIONAL CHECK



Comment: Ensure Material certification comply to Dwg D2991

0906.15 (U)

7.0 D24641700 Neoprene Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D2464-1700	Foam seal	45888 4.8173

8.0 D2585 Mounting Channel



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
4	D2585	Latch clamp	15888

★ PTO

9.0 D2586 Door Latch



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
4	D2586	Door latch	47183

10.0 D2621 Latch Plate, 350 Spacepod



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
4	D2621	latch plate	41175

4/9/19

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.05.16	16	Add additional latch per DS1 9463 Rev. A, <del>Remove core add 2</del> HySol 9330 M110970 902 cloth FG78150550 M111166	<i>[Signature]</i>	090616		<i>[Signature]</i> 09.05.16 per DS1 642	<i>[Signature]</i> 09.06.19

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 29/04/2009 3:04:00 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SIDE DOOR

Job Number: 47621

Part Number: D350589042

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D3085041

prop ass'y



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D3085-041	prop ass'y	47186

CU

12.0

AN960JD10

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

CP 05.05.16 4 8 AN960JD10 Washer 111668

CU

13.0

MS21042L3

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

CP 05.05.16 7 8 MS21042L3 Nut 111274

CU

14.0

MS27039115

Screw



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

CP 05.05.16 4 8 MS27039-1-15 Screw 1110915

CU

15.0

D37212

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Decal

batch: B45493

PC 4/4/18 (1)

16.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D2991 & IIN D350-589 and install label as per dwg

★ SEE W/O  
CHG.

090618

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 29/04/2009 3:04:00 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SIDE DOOR

Job Number: 47621

Part Number: D350589042

Job Number:



Seq. #: Machine Or Operation: Description :

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*1054019*

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick kit:

19.0

D38941

Switch Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Switch Plate

Batch:

*48896*

*[Signature]*

20.0

D38951

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch:

*46857*

*[Signature]*

21.0

D2237

Striker Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty

Part number

Description

Batch

4

D2237

Striker Plate

*46162*

*[Signature]*

22.0

D2589

Keys, Key Chain, 350 Hinge



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty

Part number

Description

Batch

1

D2589

keys, key chain

*46890*

*[Signature]*

23.0

AN34A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty

Part number

Description

Batch

6

AN3-4A

Bolt

*M103515*

*[Signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Wednesday, 29/04/2009 3:04:00 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SIDE DOOR

Job Number: 47621

Part Number: D350589042

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

MS20470AD45

Rivet, Universal Head



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty

Part number

Description

Batch

88

MS20470AD4-5

Rivet

M109031

25.0

MS21042L3

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Nut

26.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

★ ENSURE DSI 9463 Rev.A  
INCLUDED IN PAPERWORK  
09.05.16 C207106/19

9/6/19

28.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE 09.05.16 AUTH UP  
RELEASED UP DATE 09.06.19

MF 09-06-19

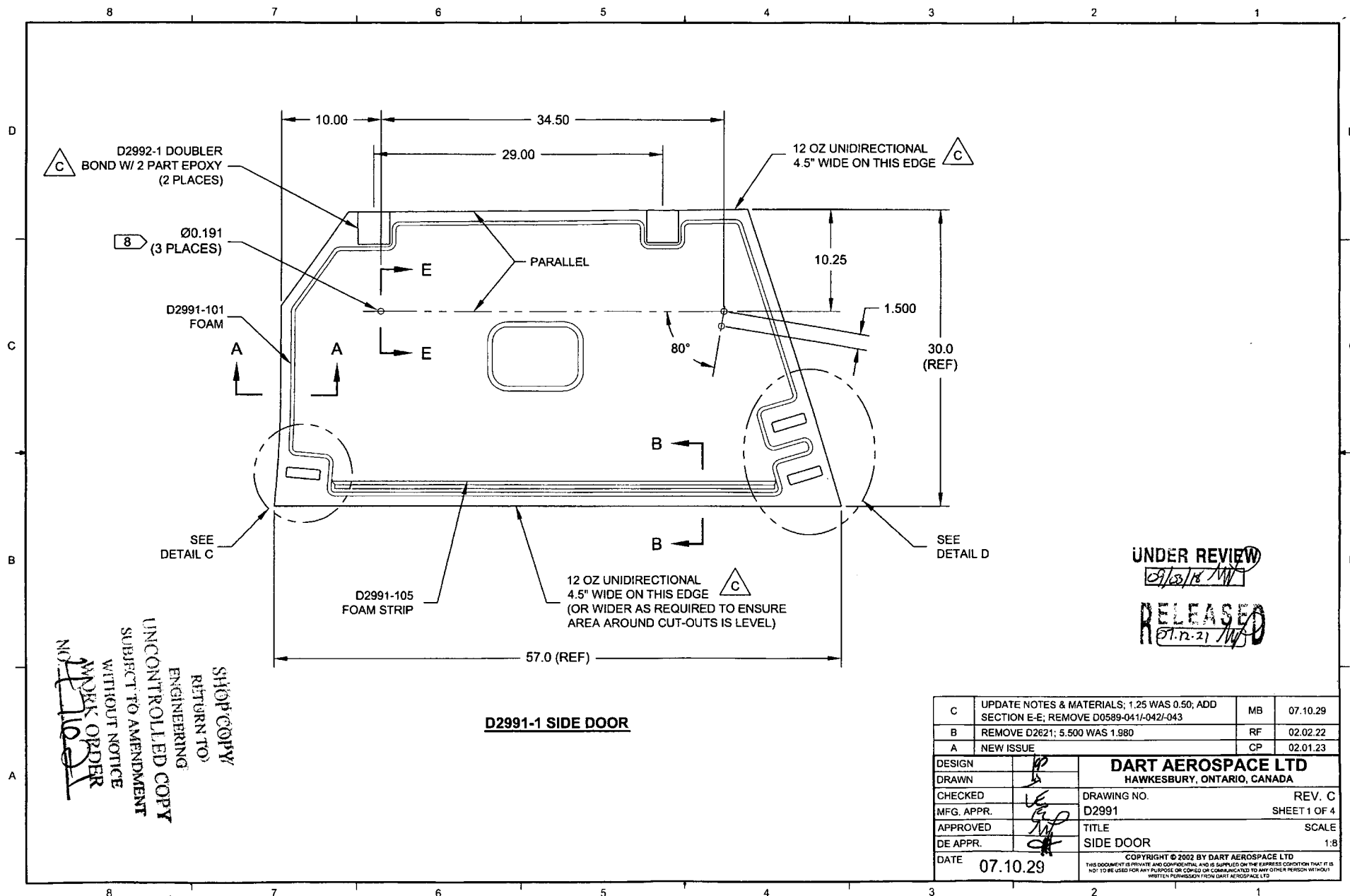
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

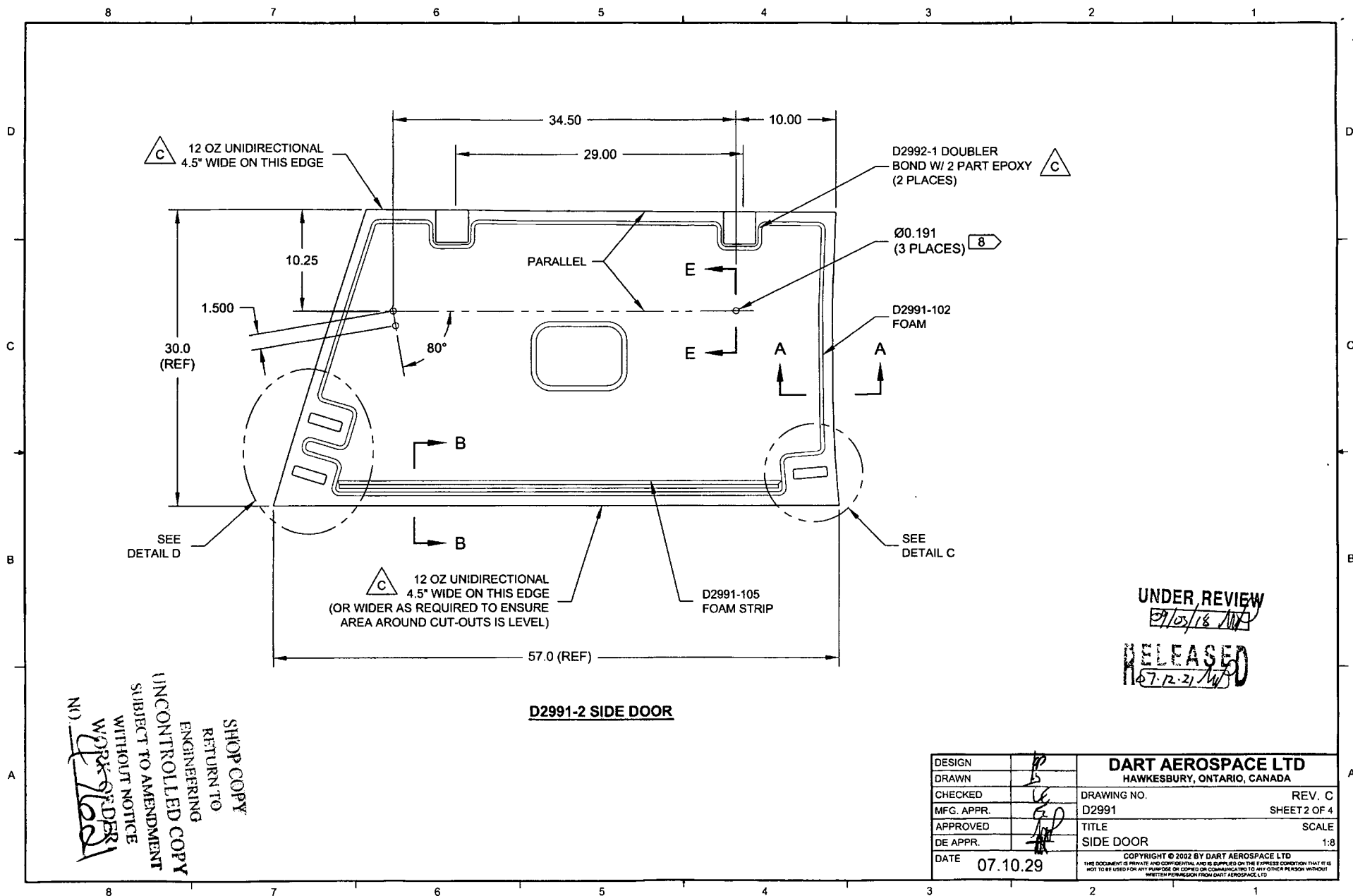
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



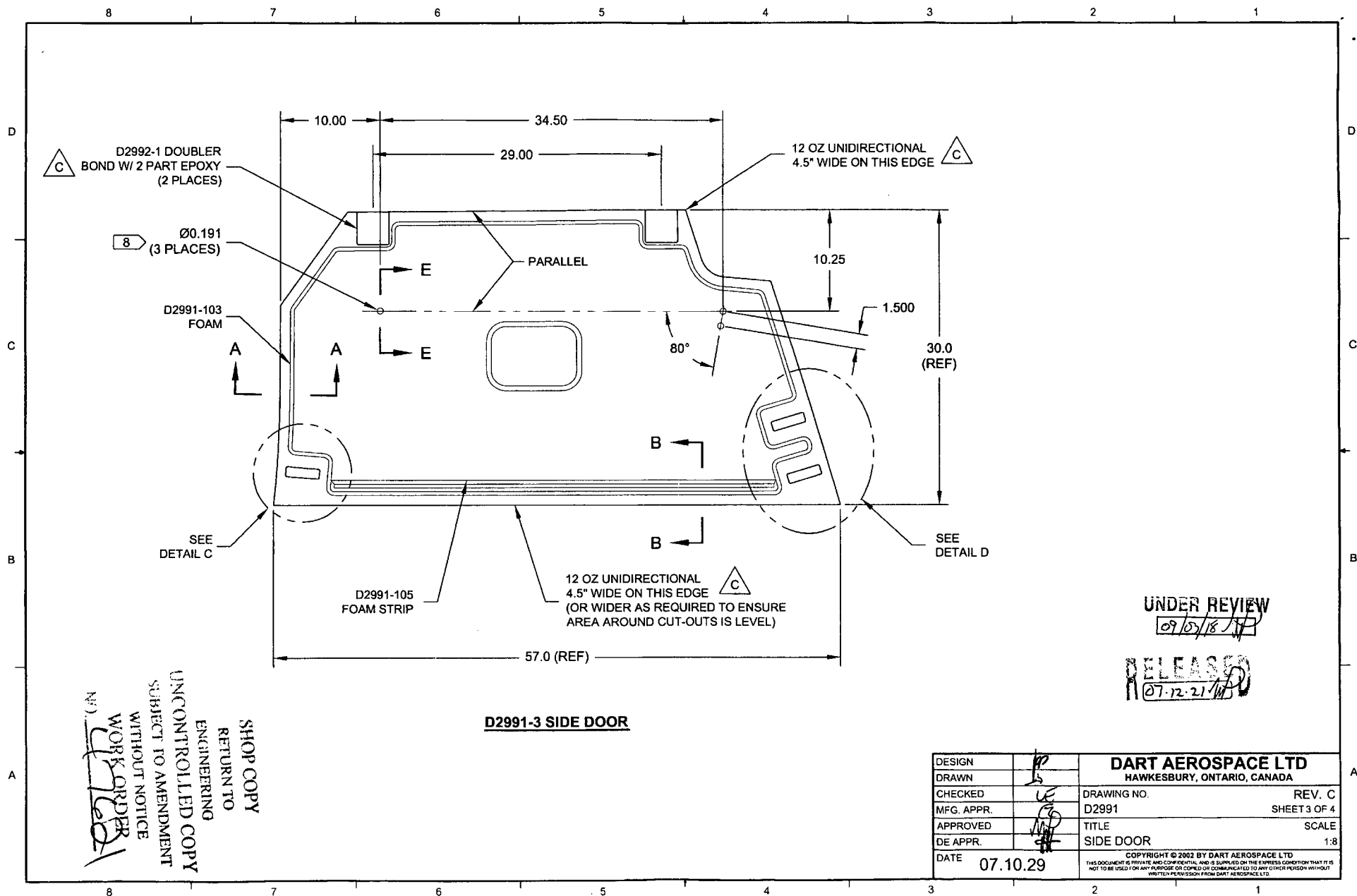


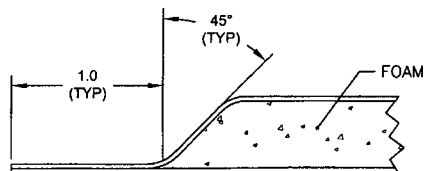
**D2991-2 SIDE DOOR**

UNDER REVIEW  
27/05/18  
RELEASED  
07.12.21

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER NO. 276021

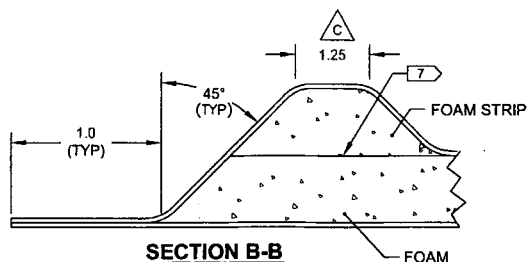
DESIGN	BP	<b>DART AEROSPACE LTD</b>	
DRAWN	B	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO. D2991	REV. C
MFG. APPR.	GP	SHEET 2 OF 4	
APPROVED	AP	TITLE SIDE DOOR	SCALE 1:8
DE APPR.	AP	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
DATE	07.10.29	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	





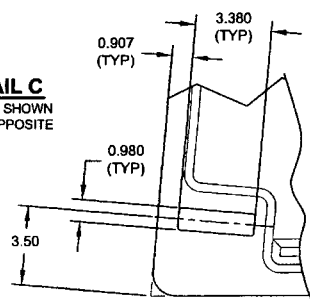
### SECTION A-A

NOT TO SCALE  
D2991-1/3 SHOWN  
D2991-2 OPPOSITE



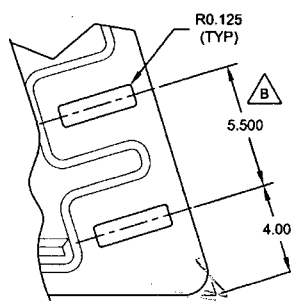
### SECTION B-B

ONE EDGE ONLY  
NOT TO SCALE, VIEW ROTATED  
D2991-1/3 SHOWN  
D2991-2 OPPOSITE



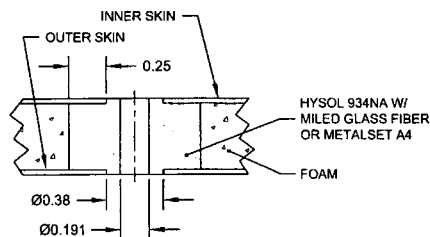
### DETAIL C

D2991-1/3 SHOWN  
D2991-2 OPPOSITE



### DETAIL D

D2991-1/3 SHOWN  
D2991-2 OPPOSITE



### SECTION E-E

TYPICAL Ø0.191  
HOLE DETAIL  
NOT TO SCALE

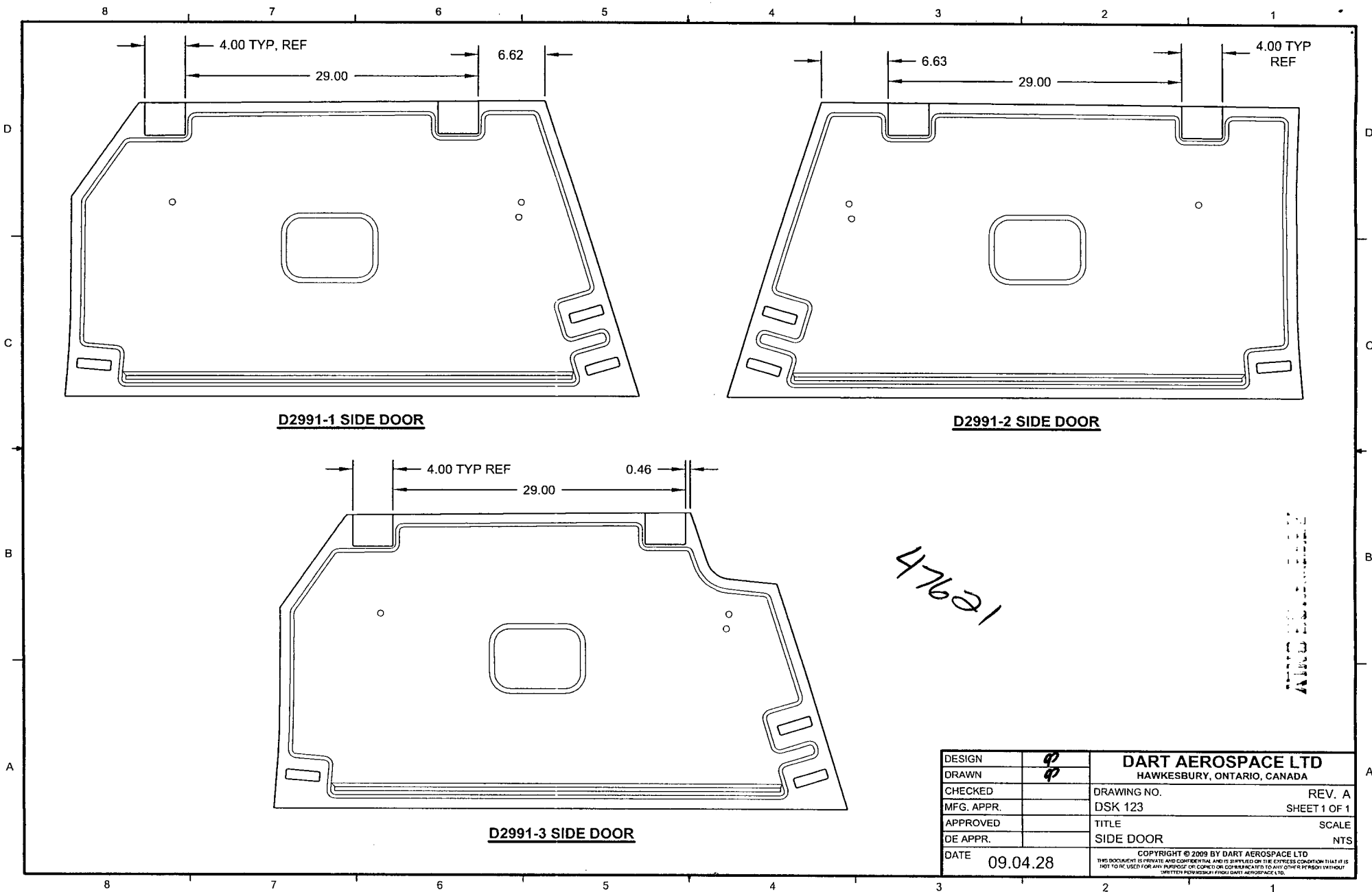
### NOTES FOR D2991-1/2/3

- 1) LAYUP PER QSI 006 AND AS FOLLOWS
- 2) MATERIALS:  
RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40  
FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL  
FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 3) FINISH INSIDE WITH DUPONT HIGHBUILD PRIMER GREY #1104S OR #1144S
- 4) USE MOLD DT8626 FOR D2991-1 SIDE DOOR  
USE MOLD DT8627 FOR D2991-2 SIDE DOOR  
USE MOLD DT8626 FOR D2991-3 SIDE DOOR (TRIM PER DT8631)
- 5) ROUTER FOAM CORE USING: DT8628 FOR D2991-1 SIDE DOOR  
DT8629 FOR D2991-2 SIDE DOOR  
DT8630 FOR D2991-3 SIDE DOOR
- 6) MAIN LAYUP: WHITE GLOSS GELCOAT #GEL 944W005  
9 OZ SATIN  
9 OZ SATIN  
FOAM  
FOAM STRIP  
9 OZ SATIN  
12 OZ UNIDIRECTIONAL (4.5" WIDE, 2 EDGES SHOWN)  
9 OZ SATIN  
RESIN (35-45% BY WEIGHT)  
PEEL PLY
- 7) BOND FOAM CORE USING POLYBOND B46F
- 8) DRILL Ø0.38 HOLE. REMOVE THE FOAM INNER LAYER 0.25 AROUND THE HOLE BETWEEN THE INNER AND OUTER SKINS. APPLY TAPE OR AN EQUIVALENT BACKER TO THE INNER SIDE OF THE HOLES TO PREVENT EPOXY FILLER FROM GOING THROUGH. FILL THE CAVITY BETWEEN THE SKINS COMPLETELY WITH HYSOL 934NA MIXED WITH MILED GLASS FIBERS TO A RATIO OF 10:1 OR METALSET A4. ALLOW THE MATERIAL TO CURE. DRILL Ø0.191 THROUGH, 3 PLACES PER DOOR. SEE SECTION E-E.
- 9) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 10) UNITS: INCHES UNLESS OTHERWISE NOTED
- 11) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 12) IDENTIFICATION: PER D2991-1/2/3 PPPs.
- 13) WEIGHT: 9 lbs (TYP)

UNDER REVIEW  
07/10/2009  
RELEASED  
07-12-21

DESIGN	10	<b>DART AEROSPACE LTD</b>	
DRAWN	5	HAWKESBURY, ONTARIO, CANADA	
CHECKED	10	DRAWING NO.	REV. C
MFG. APPR.	10	D2991	SHEET 4 OF 4
APPROVED	10	TITLE	SCALE
DE APPR.	10	SIDE DOOR	1:
DATE	07.10.29	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
1071021

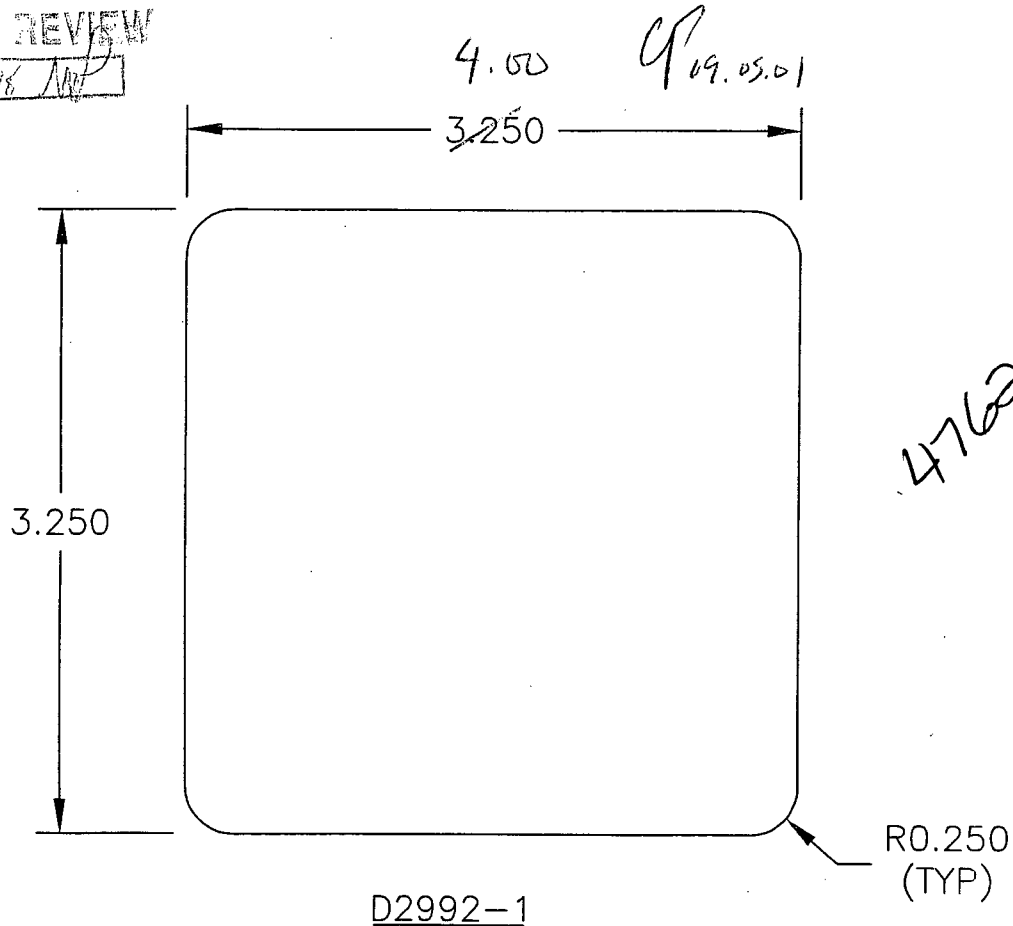




DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2992	REV. A SHEET 1 OF 1
DATE 02.01.21		TITLE DOUBLER	SCALE 1:1
A	02.01.21	NEW ISSUE	

RELEASED  
02.01.21 *#*

UNDER REVIEW  
07/03/16 *W*



NOTES:

MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 2002 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



# DELASTEK COMPOSITES

DELASTEK COMPOSITES INC.  
2699, Sième Avenue  
Local 14, PORTE -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\*Fax (819) 533-3494 \*\*

## PACKING SLIP CERTIFICATE OF COMPLIANCE

Telephone: (819) 533-5788  
Warehouse: MAIN

Invoice #	13183
Customer #	DART

Bill to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Ship to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-5200  
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by	Your PO #	GST/PST #		
12/06/2009	04/05/2009	6010	Chantal Lavoie	PO00008723			
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0050	Side Door N° D2991-1 B47619 Dwg.: D2991 Rév.: C annoté Job: 43821 U de M : Each			
1	0	1	DKC134-0051	Side Door N° D2991-2 B47621 Dwg.: D2991 Rév.: C annoté Job: 43823 U de M : Each			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department

AQ-357



Date: Lundi, 2009-06-01 11:09:53  
 Utilisateur: Marc Dubé

## Feuille de Procédé

Client : DART	Dart Aerospace Ltd.	Nom Dessin : SIDE DOOR N° D2991-2	<b>D</b>
Numéro Job : 43823		Numéro Article : DKC134-0051	
Numéro Soumission : 2623		Numéro Dessin : D2991	
Numéro B.A. :		Projet Numéro : DKC134	
Cette fois : 2009-06-01	No. B.V. :	Révision dessin : C	
Prsht Rev. : NC		Matériel : Composites	
Prem. fois : -	Type :	Date Dûe : 2009-06-08	Qté: 1 UdM: UNITE
Job précédente : 43807			

Écrit par : \_\_\_\_\_

Vérifié & Approuvé par : \_\_\_\_\_

Commentaires : N° de pièce Client: D2991-2

Process Sheet Rev.: 01 Remplacer Frekote 700 NC par Loctite Frekote Wolo et ajouter espace de N° de Lot pour les articles AACxxxx.

Produit additionnel

Numéro Job:



# Séq.: Machine ou Opération: Description:

1.0

NOTE

NOTE GÉNÉRALE DE FABRICATION


 Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs  
 Information générale de fabrication

Liste des instructions de fabrication et instruction générale de fabrication nécessaires à la fabrication de la pièce:

 IG 0008 Application de primer Dupont.  
 IG 0009 Traitement des moules agent démoulant (Freekote)  
 IG 0012 Montage de Vacuum Bagging et cuisson  
 IG 0018 Démouler une pièces de fibre de verre fabriquée en Wet Layup  
 IG 0019 Application du Gelcoat

2.0

OUTILLAGE

OUTILLAGE NÉCESSAIRE À LA FABRICATION


 Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs  
 Outillage nécessaire pour la fabrication

DKO-0095

3.0

AAC0700

N° 83634, Frekote Loctite Wolo

 Commentair Qty.: 0.025 UNITE(s)/Unit Total : 0.025 UNITE(s)  
 N° 83634, Frekote Loctite Wolo N° de Lot: \_\_\_\_\_

Date: Lundi, 2009-06-01 11:09:53  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 43823

Nom Dessin: SIDE DOOR N° D2991-2  
Numéro Article: DKC134-0051

Numéro Job:



# Séq.: Machine ou Opération: Description :

4.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
Préparation du moule

Faire la préparation du moule N° DKO-0095 à l'aide de Frekote Wolo et laisser sécher pendant 3 heures selon le QSI-006 et l'instruction générale de fabrication N° IG 0009.

Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

5.0 AAC0273

Gel Coat Blanc N° Gel 944W005

Commentair Qty.: 1.000 KILOGRAMME(s)/Unit Total : 1.000 KILOGRAMME(s)  
Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-7042-1

6.0 AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0250 PINTE(s)/Unit Total : 0.0250 PINTE(s)  
Catalyst N° DDM-9 N° de Lot: 1-22176-1

7.0 AAC0198

UN2055 styrene monomere ST

Commentair Qty.: 0.014 GALLON(s)/Unit Total : 0.014 GALLON(s)  
UN2055 styrene monomere ST N° de Lot: \_\_\_\_\_

8.0 PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
PRÉPARATION DU MATÉRIEL

Faire la préparation du matériel :

Dans une quantité de 0.2 gallon de Gel Coat N° 944W005 ajouter 2% de Catalyst N° DDM-9 et diluer à l'aide de 10% de UN2055 styrene monomere ST

Date: 1-6-09 Sceau: Temps Début: 8:10 Temps Fin: 8:25

9.0 GEL COAT.

APPLICATION DE GEL COAT



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
APPLICATION DE GEL COAT

Faire l'application du Blanc N° Gel 944W005 sur le moule N° DKO-0095 selon l'instruction Générale de fabrication N° IG 0019

Date: 1-6-09 Sceau:

Date: Lundi, 2009-06-01 11:09:53  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 43823

Nom Dessin: SIDE DOOR N° D2991-2  
Numéro Article: DKC134-0051

Numéro Job:



# Séq.: Machine ou Opération: Description :

10.0 AC0409 Tissu à délaminer Release ply B

Commentair Qty.: 5.43 VERGE(s)/Unit Total : 5.43 VERGE(s)  
Tissu à délaminer Release ply B

11.0 AC0407 Wrightlon 5200 Bleu P3

Commentair Qty.: 5.43 VERGE(s)/Unit Total : 5.43 VERGE(s)  
Wrightlon 5200 Bleu P3

12.0 AC0408 Feutre de drainage N° Airweave N 10

Commentair Qty.: 5.43 VERGE(s)/Unit Total : 5.43 VERGE(s)  
Feutre de drainage N° Airweave N 10

13.0 AC0752 Stretchlon 200 poche à vide Vert

Commentair Qty.: 12.00 PIED(s)/Unit Total : 12.00 PIED(s)  
Stretchlon 200 poche à vide Vert

14.0 AAC0276 Fiberglass 9oz Type "S" N° FG778138-125Y

Commentair Qty.: 7.30 VERGE(s)/Unit Total : 7.30 VERGE(s)  
Fiberglass 9oz Type "S" N° FG778138-125Y N° de Lot: 1-7080-1

15.0 AAC0443 Fiberglass 12 oz Unidirectional

Commentair Qty.: 4.00 VERGE(s)/Unit Total : 4.00 VERGE(s)  
Fiberglass 12 oz Unidirectional N° de Lot: 1-21729-1

16.0 AC0098 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 3.0000 RL(s)/Unit Total : 3.0000 RL(s)  
Ruban à gommer jaune #: T/AT-200Y

17.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs  
PRÉPARATION DU MATÉRIEL DART

Tailler le matériel, selon les différents patterns de découpe comme suit:

4 plis de tissus de 9.7 oz.  
1 pli de 12 oz. pour tout le contour de la pièce par 5" de large.

3 fois le sac à vide Stretchlon 200.  
3 fois le film perforé P-3  
3 fois le feutre de drainage  
2 fois le tissu à délaminer ( non nécessaire lors du bagging du core ).

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps, en les superposant les uns sur les autres.

Date: 25-5-09 Sceau: S.V.

Date: Lundi, 2009-06-01 11:09:53  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd. Nom Dessin: SIDE DOOR N° D2991-2  
Numéro Job: 43823 Numéro Article: DKC134-0051

Numéro Job:



# Séq.: Machine ou Opération: Description :  
18.0 AAC0274 Derakane 411-350 Promoté N° RV411B3020

Commentaire Qty.: 1.700 KILOGRAMME(s)/Unit Total: 1.700 KILOGRAMME(s)  
Derakane 411-350 Promoté N° RV411B3020 N° de Lot: 1-24224-1

19.0 AAC0275 Catalyst N° DDM-9

Commentaire Qty.: 0.0060 UNITE(s)/Unit Total: 0.0060 UNITE(s)  
Catalyst N° DDM-9 N° de Lot: 1-22176-1

20.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs  
PRÉPARATION DU MATÉRIEL DART

Faire la préparation de la résine selon les quantité requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 1-6-09 Heure Début: 12:30 Heure Fin: 12:35 Sceau:

21.0 LAMINAGE. LAMINAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs  
LAMINAGE PIÈCE DART

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DKO-0095 et ensuite imbiber un pli de tissu 9.7 oz.

Recommencer l'opération pour le deuxième pli.

Date: 1-6-09 Heure Début: 12:35 Heure Fin: 12:50 Sceau: N.T.

22.0 POCHÉ À VIDE 1 FAIRE LA POCHÉ À VIDE



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs  
FAIRE LA POCHÉ À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre ui suit:

- 1- Tissu à délaminer.
- 2- Film Perforé P-3.
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 1-6-09 Sceau: N.T.

Curing début: 12:35 Curing Fin: 8:00

Date: Lundi, -2009-06-01 11:09:53  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 43823

Nom Dessin: SIDE DOOR N° D2991-2  
Numéro Article: DKC134-0051

Numéro Job: 

# Séq.: Machine ou Opération: Description :

23.0 AAC0452 Polybond B46F

Commentair Qty.: 0.143 KIT(s)/Unit Total : 0.143 KIT(s)  
Polybond B46F N° de Lot: 1-6986-1

24.0 DKC134-0063 Foam Core N° D2991-102( Porte D2991-2)

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)  
Foam Core N° D2991-102 ( Porte D2991-2) N° de Lot: 43819

25.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
ASSEMBLAGE GÉNÉRALE DART

Retirez le bagging.

Appliquer une couche de polybond B64F à l'endos du foam core N° DKC134-0063 et positionner le foam sur le moule selon le dessin et selon les lignes de positionnement prévues à cet effet.

Date: 4-6-09 Heure Début: 1:35 Heure Fin: 1:50 Sceau:  N.T.

26.0 POCHÉ À VIDE 1 FAIRE LA POCHÉ À VIDE



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs  
FAIRE LA POCHÉ À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Film Perforé P-3.
- 2- Feutre de drainage
- 3- Sac à vide Stretchlon 200.

Laisser sécher pendant 2 heures minimum.

Date: 4-6-09 Sceau:  N.T.

Curing Début: 1:35 Curing Fin: 2:55

27.0 AAC0274 Derakane 411-350 Promoté N° RV411B3020

Commentair Qty.: 1.700 KILOGRAMME(s)/Unit Total : 1.700 KILOGRAMME(s)  
Derakane 411-350 Promoté N° RV411B3020 N° de Lot: 1-24224-1

28.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0040 UNITE(s)/Unit Total : - 0.0040 UNITE(s)  
Catalyst N° DDM-9 N° de Lot: 1-22176-1

Date: Lundi, 2009-06-01 11:09:53  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 43823

Nom Dessin: SIDE DOOR N° D2991-2  
Numéro Article: DKC134-0051

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

29.0


PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
PRÉPARATION DU MATÉRIEL DART

Faire la préparation de la résine selon les quantités requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 9-6-09 Heure Début: 11:00 Heure Fin: 11:05 Sceau:  1

30.0

LAMINAGE.

LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
LAMINAGE PIÈCE DART

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du plis de tissu 12 oz. tout le tour de la porte en prenant bien soin que les deux bandes allant dans le coin droit en bas se superposent

Faire le laminage du dernier pli de 9.7 oz.

Date: 9-6-09 Heure Début: 11:05 Heure Fin: 11:50 Sceau:  N.T.

31.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs  
FAIRE LA POCHE À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer.
- 2- Film perforé P-3.
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200.

Laisser sécher pendant 4 heures minimum.

Date: 9-6-09 Heure Début: 11:50 Heure Fin: 12:00 Sceau:  N.T.

Curing Début: 11:05 Curing Fin: 8:00

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SIDE DOOR N° D2991-2

Numéro Job: 43823

Numéro Article: DKC134-0051

Numéro Job:



# Séq.: Machine ou Opération: Description :

32.0 DÉMOULAGE 1 DÉMOULAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
DÉMOULAGE PIÈCE DART

Démouler la pièce en faisant bien attention de ne pas abimer les coins et les " edges ". Selon l'instruction générale de fabrication N° IG 0018

Date: 10-6-09 Sceau:



N.T.

33.0 TRIMAGE 3 TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
TRIMAGE COMPOSITES DART

À l'aide du gabarit N° DKO-0119 trimer la pièce en utilisant un router muni d'un couteau 1/4" et d'un " Bushing " 1/16" de mur.

Percer les " Latch " et les trous de penture selon le dessin N° D2991.

Date: 10-6-09 Sceau:



N.T.

34.0 AAC0701 Araldite 2043

Commentair Qty.: 0.150 UNITE(s)/Unit Total : 0.150 UNITE(s)

Araldite 2043

N° de Lot:

1-22083-1 HYSOL 934

Pour les insert seulement



35.0 AAC0873 Fibre de verre Miapoxy 66

Commentair Qty.: 0.0002 GALLON(s)/Unit Total : 0.0002 GALLON(s)

Fibre de verre Miapoxy 66

N° de Lot:

1-6872-1

36.0 TRIMAGE 3 TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
TRIMAGE COMPOSITES DART

À l'aide du Gabarit N° DKO-0119 Percer les 3 trous de 1/4" Dia.

À l'aide d'une clé Allen et en faisant bien attention de ne pas abimer les Skins de la pièce, venir faire un dégagement de 1/2" Dia dans le Foam Core entre les Skin intérieur et extérieur.

À l'aide de masking Tape, masquer le trous de la skin extérieur.

À l'aide d'un mélange de résine Hysol 934NA / Fibre courte Miapoxy 66 et d'une seryngue, venir remplir les dégagements de 1/2" Dia préalablement fait dans le foam Core.

Laisser sécher.



ate: Lundi, 2009-06-01 11:09:53  
Utilisateur: Marc Dubé

## Feuille de Procédé

Cliant: DART Dart Aerospace Ltd.  
Numéro Job: 43823

Nom Dessin: SIDE DOOR N° D2991-2  
Numéro Article: DKC134-0051

Numéro Job:



# Séq.: Machine ou Opération: Description :

Date: 10-6-09 Sceau:



37.0

TRIMAGE

TRIMAGE DE FINITION



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
TRIMAGE DE FINITION

À l'aide du gabarit N° DK0-0119 Repercer les 3 trous de 1/4" Dia.

Date: 11-6-09 Sceau:



38.0

AAC0701

Araldite 2043

Commentaire Qty.: 0.125 UNITE(s)/Unit Total : 0.125 UNITE(s)  
Araldite 2043 N° de Lot: 1-24284-1

39.0

AAC0697

N° D2992-1, Doubler

Commentaire Qty.: 2 UNITE(s)/Unit Total : 2 UNITE(s)  
N° D2992-1, Doubler N° de Lot: 1-7079-1

40.0

ASSEMBLAGE

ASSEMBLAGE GÉNÉRALE DES PIÈCES



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
ASSEMBLAGE GÉNÉRALE DES PIÈCES

À l'aide de l'adhésif N° ~~Physol 3300~~ <sup>Araldite 2043</sup>, assembler le doubler N° D2992-1 sur la pièce de composite selon le dessin.

Date: 11-6-09 Sceau:



N.T

41.0

AAC0683

Dupont Primer N° 7704S

Commentaire Qty.: 0.1800 UNITE(s)/Unit Total : 0.1800 UNITE(s)  
Dupont Primer N° 7704S N° de Lot: 1-22968-1

42.0

AAC0685

Dupont Activator - Reducer Chromabase N° 7775S

Commentaire Qty.: 0.0450 UNITE(s)/Unit Total : 0.0450 UNITE(s)  
Dupont Activator - Reducer Chromabase N° 7775S N° de Lot: 1-23133-2

43.0

PRIMER

APPLICATION DE PRIMER



Commentaire Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs  
APPLICATION DE PRIMER

Appliquer le primer selon I.G. 0008

Date: 11/06/09 Sceau:



Date: 12/06/09 Sceau:



Date: Lundi, 2009-08-01 11:09:53

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 43823

Nom Dessin: SIDE DOOR N° D2991-2  
Numéro Article: DKC134-0051

Numéro Job:



# Séq.: Machine ou Opération: Description :

Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

44.0

INSPECTION 3

INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
INSPECTION PIÈCE DART

Faire l'inspection selon le dessin N° D2991

12-06-09

Date: \_\_\_\_\_ Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: \_\_\_\_\_



45.0

EMBALLAGE

EMBALLAGE ET ENTREPOSAGE



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
EMBALLAGE ET ENTREPOSAGE

Faire l'emballage des pièces.

Quantité: 1 Date: 12-6-09 Sceau: \_\_\_\_\_



Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-589 REV. E

AND

INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-589 REV. 1

REF CANADIAN STC: SH92-41

REF FAA STC: SH1012NE

D35X-589-041/-042/-043 Side Door Assembly kits at CHG 004 have an additional latch on the trailing edge to provide better fit and security. The side door kits at CHG 004 should be installed per IIN-D350-589 Rev. E, except a total of (4) D2237 striker plates are now installed. The parts list is updated as follows:

ADD:

Qty -041	Qty -042	Qty -043	Part Number	Description
X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
	X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
		X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
1	1	1	D2237	Striker Plate
1	1	1	D2585	Latch Clamp
1	1	1	D2586	Latch
1	1	1	D2621	Latch Plate
1	1	1	AN960JD10	Washer
2	2	2	MS20470AD4-5	Rivet
1	1	1	MS21042L3	Nut (or MS21042-3)
1	1	1	MS27039-1-15	Screw

The DSI-9463-011 kit is available for customers with earlier model D35X-589-041/-042/-043 doors to add an additional latch on the trailing edge of the door.

Qty -011	Part Number	Description
X	DSI-9463-011	DOOR LATCH KIT
1	D2237	Striker Plate
1	D2464-1700	Seal
1	D2585	Latch Clamp
1	D2586	Latch
1	D2621	Latch Plate
1	AN960JD10	Washer
2	MS20470AD4-5	Rivet
1	MS21042L3	Nut (or MS21042-3)
1	MS27039-1-15	Screw
2 SQ. FT	N/A	9.7oz 7781 'S' GLASS UNIVERSAL WEAVE

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 47621

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED  
BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 09.05.26  
CERT. NO.: SH92-41  
ISSUE NO.: 8

A	NEW ISSUE	CP	09.05.26
DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	DSI 9463	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SIDE DOOR MODIFICATION	NTS
DATE 09.05.26		COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

**To install the DSI-9463-011 Door Latch Kit:**

- 1) Remove the D35X-589-041/-042/-043 door from the aircraft. Remove the D2464-1700 Seal as required to access the composite structure.
- 2) Trim foam core of door 11.0" (280mm) above the aft door latch as shown in Figure 2 of this service instruction. Bevel foam at 45°.
- 3) Apply (2) layers of 9 oz cloth covering the trimmed area, as shown in Section A-A of this service instruction. Acceptable materials for the composite modification are specified in section 7.0 of QSI 037. Cure at room temperature for 24 hours.
- 4) Temporarily locate the D2621 Latch Plate as shown in Figure 3 of this service instruction. Use latch plate as a template and trace the inner rectangle. Cut a hole through the door skin using the traced rectangle to fit a D2586 Latch. Deburr edges of hole and seal edges with potting resin.
- 5) Touch-up the paint finish with one coat of MIL-P-23377 or MIL-P-23377 primer and 2-3 coats of MIL-C-85285 polyurethane paint to match original finish.
- 6) Install D2621 Latch Plate, D2585 Latch Clamp, D2586 Latch, and associated fasteners in accordance with Figure 52-4 of ICA-D350-589.
- 7) Reinstall the door on the aircraft using existing hardware.
- 8) Locate and install a D2237 Striker Plate opposite the new latch location per Figure 52-4 of ICA-D350-589.
- 9) Install the D2464-1700 Seal around the outside edge of the door as shown in Figure 52-4 of ICA-D350-589.
- 10) Check the doors and latches for proper operation by opening and closing the door. Adjust latches as required.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 47621

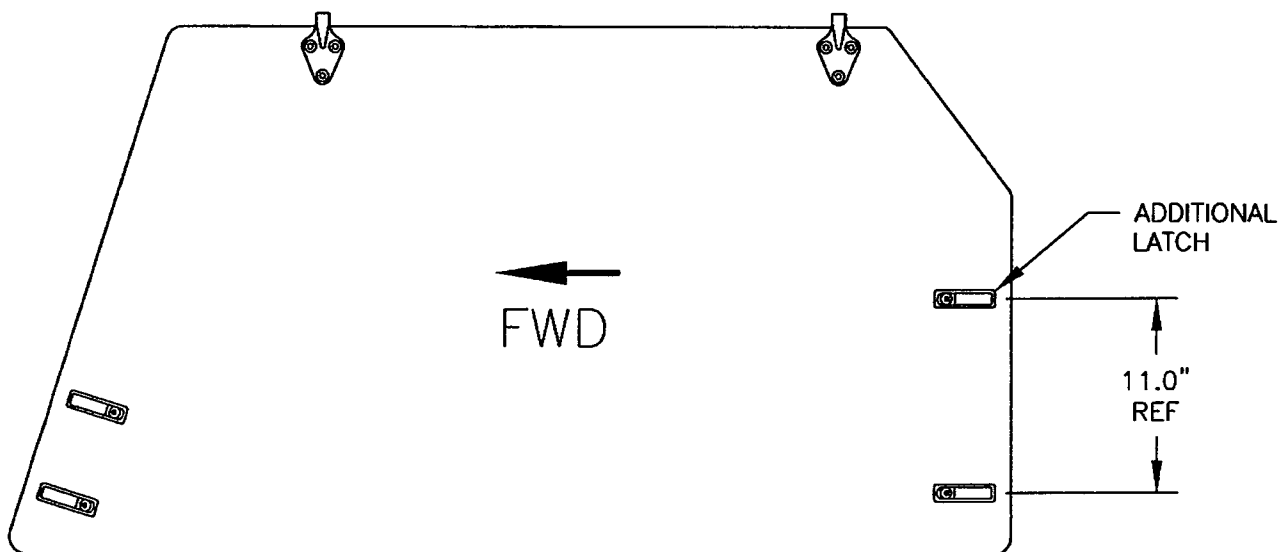
CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: [Signature]  
D. SHEPHERD (DE # 02)

DATE: 09.05.26  
CERT. NO.: SH92-41  
ISSUE NO.: 8

DESIGN	<u>[Signature]</u>	<b>DART AEROSPACE LTD</b>	
DRAWN	<u>[Signature]</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>[Signature]</u>	DRAWING NO.	REV. A
MFG. APPR.	<u>[Signature]</u>	DSI 9463	SHEET 2 OF 5
APPROVED	<u>[Signature]</u>	TITLE	SCALE
DE APPR.	<u>[Signature]</u>	SIDE DOOR MODIFICATION	NTS
DATE	09.05.26	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



**FIGURE 1: D350-589-041 DOOR ASSEMBLY (SHOWN)  
D35X-589-042/-043 (SIMILAR)**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 47621

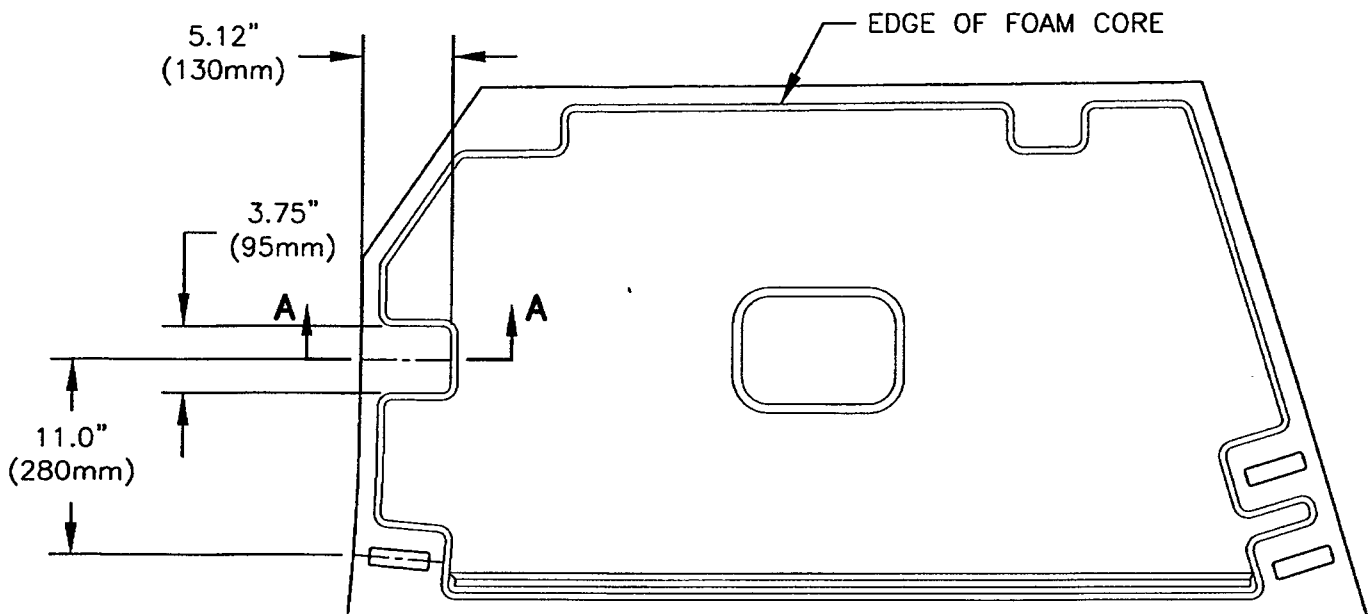
CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED  
*[Signature]*

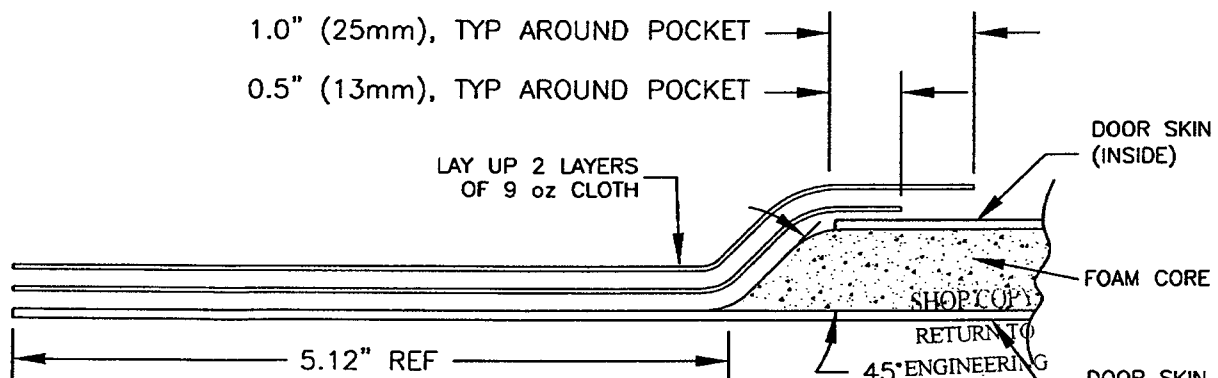
BY: D. SHEPHERD (DE #02)

DATE: 09.05.26  
CERT. NO.: SH92-41  
ISSUE NO.: 8

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	DSI 9463	SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SIDE DOOR MODIFICATION	NTS
DATE <b>09.05.26</b>		COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



**FIGURE 2: TRIMMING FOAM CORE  
(VIEW LOOKING AT INSIDE OF DOOR)  
(-041 SHOWN. -042/-043 SIMILAR)**



**SECTION A-A**

SHO COPY  
RETURN TO  
45° ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 47621

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

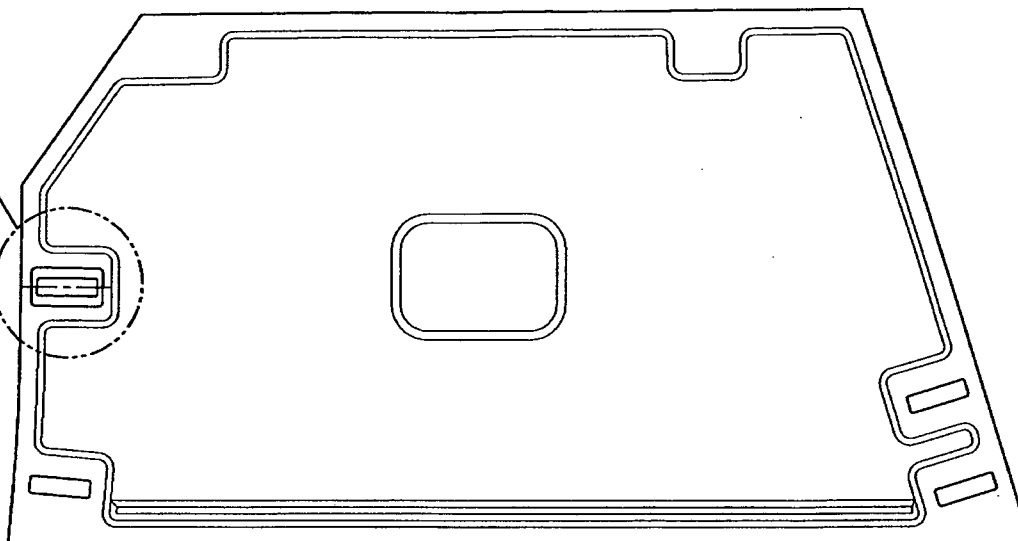
APPROVED

BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 09.05.26  
CERT. NO.: SH92-41  
ISSUE NO.: 8

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	DSI 9463	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SIDE DOOR MODIFICATION	NTS
DATE	09.05.26	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

SEE  
DETAIL B

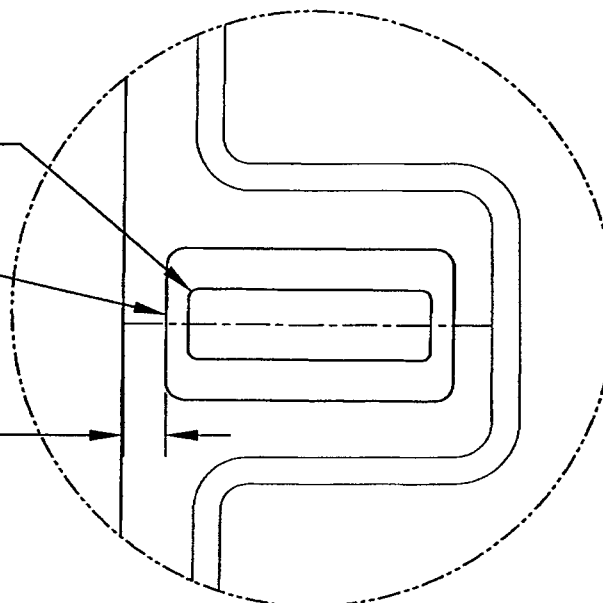


**FIGURE 3: CUTTING LATCH HOLE**

CUT HOLE THROUGH  
SKIN USING D2621 AS  
TEMPLATE

D2621 LATCH PLATE

0.60"  
(15.2mm)



**DETAIL B**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 47621

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: [Signature]  
D. SHEPHERD (DE # 02)

DATE: 09.05.26  
CERT. NO.: SH92-41  
ISSUE NO.: 8

DESIGN	<u>[Signature]</u>	<b>DART AEROSPACE LTD</b>	
DRAWN	<u>[Signature]</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>[Signature]</u>	DRAWING NO.	REV. A
MFG. APPR.	<u>[Signature]</u>	DSI 9463	SHEET 5 OF 5
APPROVED	<u>[Signature]</u>	TITLE	SCALE
DE APPR.	<u>[Signature]</u>	SIDE DOOR MODIFICATION	NTS
DATE	09.05.26	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	